

Work Order ID 86118

Wednesday, June 20, 2012 3:01:49 PM

86118

Page 1

Item ID: D3492-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug Assembly
 Start Date: 6/20/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/20/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MFC Date: 12-06-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3492	D

180 0.00

180

Hand Finish Memo 0.00
 Hand Finishing ASSEMBLE AS PER DRAWING D3492-043

8 SP 12-6-20

190 QC5- Inspect part completeness to step on W/O 0.00

190

QC Memo 0.00
 Quality Control

8 12 12-6-20

200 Identify as per dwg & Stock Location: 0.00

200

Packaging Memo 0.00
 Packaging

80 12/6/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3492-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Plug Assembly

Stop ***NS2***

Start Date: 6/20/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/20/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 12/06/20

MLJ 12/06/20

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 20, 2012 2:59:08 PM

Page 1

Work Order ID: 86118
 Parent Item: D3492-043
 Parent Item Name: Plug Assembly

Start Date: 6/20/2012 Required Date: 6/20/2012
 Start Qty: 8.00 Required Qty: 8.00

Comments: IPP Rev: A 06.03.21 New Issue JLM
 IPP Rev: B 06-08-28 As per Rev B JLM
 IPP Rev: C 07-12-06 Rev C dwg DD verified by: EC
 IPP Rev: D 08-05-07 add note to count qty DD verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-3 Plug		Manufactured	No				Each	147.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP-A				147					
				81967				5					
				83099 ✓				20					
				83529				122					
NAS1611-013 O-RING		Purchased	No				Each	325.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				325					
				116582				5					
				117291				2					
				117887				53					
				119623				36					
				121584				5					
				121825 ✓				182					
				121826				42					

8 8/12/12 6-20

8 8/12/12 6-20

8

W/O:		WORK ORDER CHANGES					
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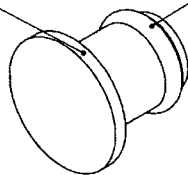
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



456118

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X	X						D3492-041	PLUG ASSEMBLY
		X					D3492-043	PLUG ASSEMBLY
			X				D3492-045	PLUG ASSEMBLY
				X			D3492-047	PLUG ASSEMBLY
					X		D3492-049	PLUG ASSEMBLY
						X	D3492-051	PLUG ASSEMBLY
							D3492-053	PLUG ASSEMBLY
1	1						D3492-1	PLUG
		1					D3492-3	PLUG
			1				D3492-5	PLUG
				1			D3492-7	PLUG
					1		D3492-9	PLUG
						1	D3492-11	PLUG
							D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
	1					1	NAS1611-012	O-RING
					1		NAS1611-013	O-RING
							NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2011-05-30

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	08.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	J.F.B.	D3492	SHEET 1 OF 2
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

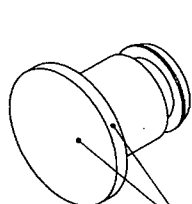
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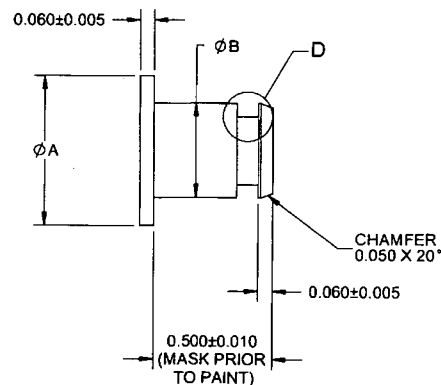
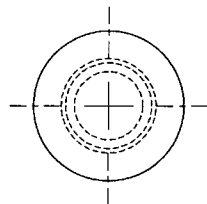
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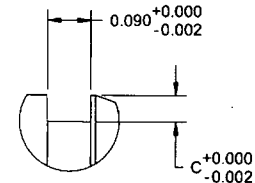
NOTE: Date & initial all entries



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

#86118

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2011-05-30

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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